

Work Order ID 84682-1

84682

Page 1

May-17-12 3:02:05 PM

SPLIT-1

Item ID: D3282-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Float Web (206L/407)

Start Date: 17/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3282

D

100

0.00

100

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Cut to length as per Dwg D3282.
2- inspect for surface damage as per QSI0018
3- Deburr

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282
2-Deburr

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10 12-05-23
PTC

OK 12/08/06

10

OK 12/08/06

10

W/O: 84682-1

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3282-041 PAR #: _____ Fault Category: Skid tube. NCR: Yes No DQA: Atf Date: 12/08/13
 Resolution: _____ Disposition: Scrap QA: N/C Closed: Atf Date: 12/08/14

NCR: 12-1678

WORK ORDER NON-CONFORMANCE (NCR)

\$ 313.86

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-5-23	100	1-D2792-130 B72839 Found with a severe Twist. 0.400"	<u>AS</u> 12/5/24 12/20/24	<u>Scrap</u>	<u>AS</u> 12-5-24	<u>OK</u> 12/05/24	<u>AS</u> 12/05/24	<u>AS</u> 12/05/24

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84682

84682

Page 3

Item ID: D3282-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Float Web (206L/407)

Start Date: 17/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

Skidtubes

Skidtubes

Memo

1-Install doublers as per Dwg D3282.

0.00

0.00

3

CF 12.8-9

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS 16 17/05/09

(13)

180

180

Packaging

Packaging

Identify as per dwg & Stock Location: LG

Memo

0.00

0.00

3

SAD 120809

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84682

May-17-12 3:02:05 PM

84682

Page 4

Item ID: D3282-041

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Flout Web (206L/407)

Start Date: 17/05/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

11208-10

12/8/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-17-12 3:02:09 PM

Page 1

Work Order ID: 84682

84682

Parent Item: D3282-041

D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 17/05/2012

Required Date: 15/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:B05.09.23Procedure changeKJ/JLM
remove LPS as per dwg revD DD verf:JLM

IPP REV:C 11.09.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2792-130

Manufactured

No

100

Each

21.0000

1

10

D2792-130

EXTRUSION

**

10 12-05-23

Location

Loc Qty

Loc Code

MAT006

21

72839

21

D3283-1

Manufactured

No

160

Each

24.0000

2

20

D3283-1

Doubler

**

CF 12-8-9

Location

Loc Qty

Loc Code

ST176

24

82125

24

MS20470AD4-7

Purchased

No

160

Each

1,503.000

57

570

MS20470AD4-7

Rivet, Universal Head

**

CF 12-8-9

Location

Loc Qty

Loc Code

ST139

1186

121415

1186

ST319

52

120769

52

ST320

265

116081

117

118614

148

520 208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 24682
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.620	✓		Ver M-type 71-04	
1.500	+/-0.010	1.500	✓		Ver M-type 71-04	
3.000	+/-0.010	3.000	✓		"	
6.000	+/-0.010	6.000	✓		"	
1.250	+/-0.010	1.250	✓		"	
30.000	+/-0.010	30.000	✓		M-type 71-04	
1.500	+/-0.010	1.500	✓		"	
72.01	+/-0.030	72.010	✓		"	
61.75	+/-0.030	61.750	✓		"	
57.50	+/-0.030	57.500	✓		"	
49.19	+/-0.030	49.190	✓		"	
43.94	+/-0.030	43.940	✓		"	
39.69	+/-0.030	39.690	✓		"	
26.68	+/-0.030	26.680	✓		"	
0.55	+/-0.030	0.555	✓		Ver M-type 71-04	
1.970	+/-0.010	1.970	✓		"	
2.38	+/-0.030	2.380	✓		"	
0.05	+/-0.030	0.055	✓		"	

Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 12/08/06	Date: 12/08/07	Date:

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	[Signature]

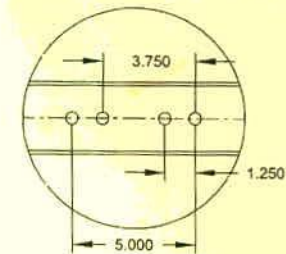
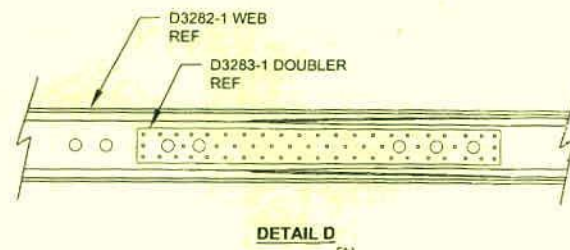
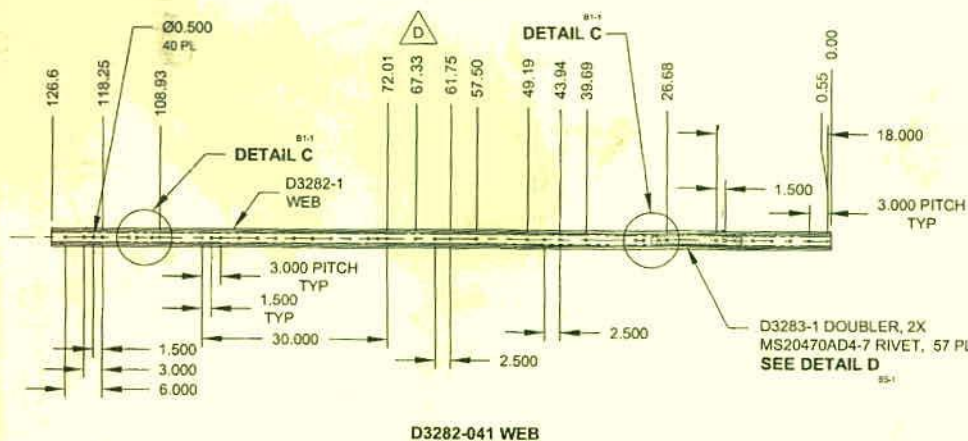
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTE: RIVET HOLES/DOUBLER NOT SHOWN FOR CLARITY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24682 MLT
12/05/22

- NOTES:
- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: 20.0 lbs
 - 8) SEE PAGE 2 FOR MACHINING DETAILS

D	ADD ADDITIONAL HOLE (ZN D5-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.18
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	SC	D3282	SHEET 1 OF 2
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC	

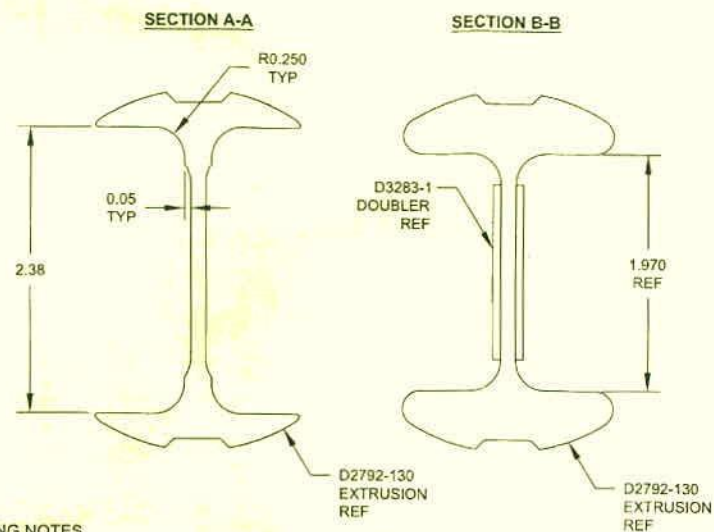
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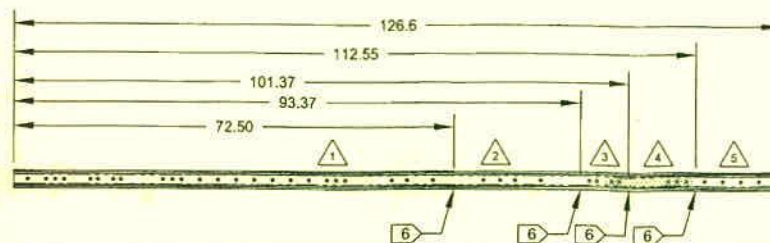
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D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	GE	DRAWING NO	REV. D
MFG. APPR.	GE	D3282	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.		WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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